



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3574-2

Job Sheet 168903



ASAP please

Part No: D3574-2

Job Qty: 1 ea

Part Name: Cabin Floor Protector



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/24/17

Job Tracking No:

Due Date: 11/27/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Customer: Heliquest Aviation Inc (CHQWE01)

#37, 27018 Sh 633, Rural Route # 1 Sturgeon County, AB, T8T 0E3 Canada ph:(780) 458-3005 fx:(780) 458-3336.

Note: DWG REV B IPP Rev :A New Issue 07-01-22 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/25/17	0.00	0.00	Start Up Waterjet		
100	Waterjet	1 pcs		11/25/17	0.72	0.43	Waterjet1		
110	QC	1 pcs		11/25/17	0.00	0.00	QC2		
120	QC	1 pcs		11/25/17	0.00	0.00	QC8		
130	Small Fab	1 pcs		11/27/17	0.00	0.22	Small Fab		
140	QC	1 pcs		11/27/17	0.00	0.00	QC5		
150	Packaging	1 pcs		11/27/17	0.00	0.00	Packaging3		
160	QC21-SA	1 Ea		11/27/17	0.00	0.00	QC21		

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	MLEXS.125-F60029-04	22	5,637	0	0

Part Specifications

Specifications could not be found.

Plex 11/24/17 12:28 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Dev: _____				Disposition			
Job No: 168903 Mfg Date: 11/24/17 Start up Operation D3574-2 Revision: _____ Operation: _____ Change No: _____				Completed By _____			
				Lead hand / Supervisor Approval Verification _____			
				QC / QA Coordinator Approval _____			
				Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due		☐ Pres ☐ Ben ☐ Cen ☐ Crai ☐ Crin ☐ Cufi ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter		DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com S013460 AEROSPACE Cabin Floor Protector DART Aerospace Misaligned/off center Fit/Function Mislabeled Un-set Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes	

DART AEROSPACE LTD		Work Order:	168903
Description: Cabin Floor Protector		Part Number:	D3574-2
Inspection Dwg: D3574 Rev: B		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	Ø3.002				
7.37	+/-0.030	7.381				
10.75	+/-0.030	10.758				
11.00	+/-0.030	11.021				
15.25	+/-0.030	15.264				
25.87	+/-0.030	25.882				
39.75	+/-0.030	39.754				
44.75	+/-0.030	44.76				
53.51	+/-0.030	53.52				
63.50	+/-0.030	63.51				
65.25	+/-0.030	65.25				
10.75	+/-0.030	10.76				
11.00	+/-0.030	11.00				
14.75	+/-0.030	14.76				
25.50	+/-0.030	25.50				
25.75	+/-0.030	25.76				
26.00	+/-0.030	26.00				
32.87	+/-0.030	32.88				
38.81	+/-0.030	38.82				
45.00	+/-0.030	45.00				
48.25	+/-0.030	48.25				
58.38	+/-0.030	58.39				
61.25	+/-0.030	61.26				
64.13	+/-0.030	64.14				
64.63	+/-0.030	64.64				
66.50	+/-0.030	66.50				
7.50	+/-0.030	7.51				
9.50	+/-0.030	9.50				
10.38	+/-0.030	10.40				
10.88	+/-0.030	10.89				
14.50	+/-0.030	14.51				
16.56	+/-0.030	16.57				
18.75	+/-0.030	18.75				
24.13	+/-0.030	24.14				

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

DART AEROSPACE LTD		Work Order:	108905
Description: Cabin Floor Protector		Part Number:	D3574-2
Inspection Dwg: D3574 Rev: B		Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.50	+/-0.030	26.50			VRC-02 Tape	
30.50	+/-0.030	30.50				
33.88	+/-0.030	33.89				
39.50	+/-0.030	39.50				
40.25	+/-0.030	40.25				
43.50	+/-0.030	43.51				
46.60	+/-0.030	46.60				
7.63	+/-0.030	7.64				
11.00	+/-0.030	11.00				
11.50	+/-0.030	11.50				
16.75	+/-0.030	16.76				
19.00	+/-0.030	19.00				
22.50	+/-0.030	22.50				
30.75	+/-0.030	30.75				
32.63	+/-0.030	32.64				
32.75	+/-0.030	32.75				
35.13	+/-0.030	35.15				
36.50	+/-0.030	36.50				
40.00	+/-0.030	40.00				
41.88	+/-0.030	41.89				
43.63	+/-0.030	43.64				
0.125	+/-0.010	0.125				

Measured by:	SC	Audited by:	38	Prototype Approval:	N/A
Date:	11/11/24	Date:	NOV 24 2017	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	
B	08.07.31	47.75 dimension removed	KJ/DD	
C	09.05.15	Dimensions updated per Dwg Rev B	KJ	